

Date: Tuesday, 19/08/2008 4:07:21 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 90 DEGREE BLADE SUPPORT ASSY
Job Number : 41510	
Estimate Number : 13386	
P.O. Number :	
This Issue : 19/08/2008 S.O. No. :	Part Number : PB6743001 <i>6743001-157 - pb-147</i>
Prsht Rev. : NC	Drawing Number : B6743001 PAGE24
First Issue : / / Type : SMALL / MED FAB	Project Number : N/A
Previous Run : 41214	Drawing Revision : B1
Written By :	Material :
Checked & Approved By : <u>JUL 08 8.20</u>	Due Date : 18/09/2008 Qty: 20 Um: Each
Comment : Est Rev:A 08-06-19 new issue DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.6241 sf(s)/Unit Total: 12.4824 sf(s)
 6061-T6 .090 Sheet
 batch: 108595 **IB 8-9-3**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001-147 /
 Dwg Rev: B1
 Prog Rev: B1 **IB 8-9-3**
 2-Deburr if necessary **IB 8-9-3**

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8 0209/04 (470)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Form as per dwg B67-43001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41510

Part Number: PB674300167147

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PB6743001149

Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)
Side Plate

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI/005 4.1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)
Nutplate

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)
RIVET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41510

Part Number: PB674300187147

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PR 6743001-147

X	First Article	X	Prototype
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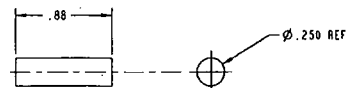
Measured by:	RB
Date:	8-9-3

Audited by:	
Date:	08/09/04

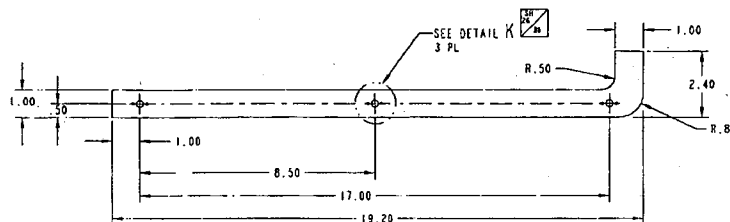
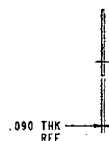
Prototype Approval:	N
Date:	7

A handwritten signature in black ink, appearing to be "A. J." or similar, located at the bottom right of the page.

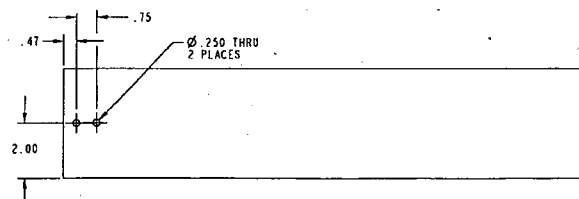
RELEASED
77 06 01 20



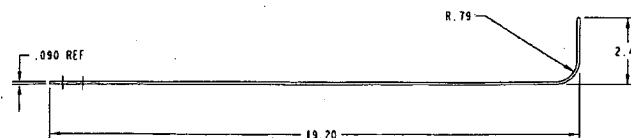
① -155 PIN
MATL: .250 RND, 303 SS
AMS5640 COND A
SCALE 2.000



④ -149 SIDE PLATE
MATL: .090 THK, 6061-T6, QQ-A-250/11
SCALE 0.500

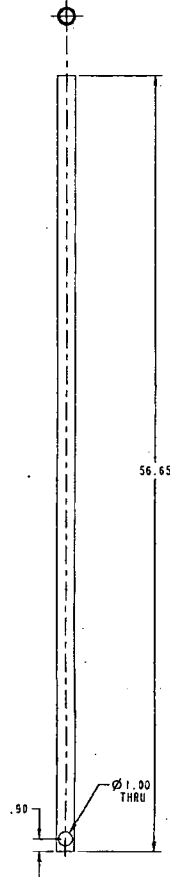
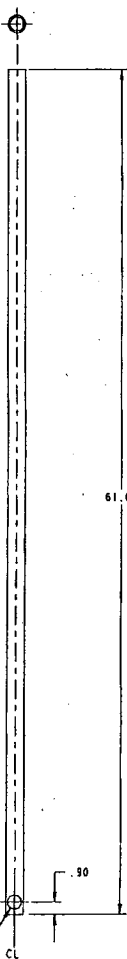


② -147 SUPPORT PLATE
MATL: .090 THK, 6061-T6, QQ-A-250/11
SCALE 0.500



⑤ -259 INNER TUBE
MATL: 1.25 OD X .125 WALL, 6061-T6, WW-T-700/6
SCALE 0.250

⑥ -255 INNER TUBE
MATL: 1.25 OD X .125 WALL, 6061-T6, WW-T-700/6
SCALE 0.250



PREMIER AVIATION, INC.
5501 Aviation Parkway, Grand Prairie, Texas 75052
REV. 0105UV8 B67-43001 84
SCALE: WT. SHEET 24 OF 45

ORIGINAL

NO WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AERIAL
ENGINEERING
RETURN TO
PROJ COPY
NO 4510